



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D4634-143
Job Sheet 167077-K



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description: **DAS**

Ship Via:

D4634 Rev. G

35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	<i>D.M.L 18-2-18</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	<i>D.M.L 18-2-18</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	<i>D.M.L 18-2-18</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	38 9-89 <i>FEB 21 2018</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>D.M.L 18-2-27</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	DAS 21 9-89 <i>MAR 07 2018</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	-D4634-3 <i>5043247</i>	1	2	0	0
	D4636-5 <i>5033865</i>	2	43	0	0
	D4647-1 <i>5033864</i>	1	4	0	0
	D4664-5 <i>5033863</i>	6	39	0	0
	D4712-1 <i>5033862</i>	2	4	0	0
	D4732-21 <i>5033861</i>	1	6	0	0
	D4732-25 <i>5033860</i>	1	7	0	0
	D5021-3 <i>5011840</i>	1	2	0	0
	MPNY-750S-9-C <i>5033853</i>	3	570	0	0
	MS20426AD3-4 <i>5033851</i>	4	5,055	0	0
	MS20426AD4-6 <i>5033850</i>	4	2,797	0	0
	MS21059L08 <i>5033849</i>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected L _____ _____ r Deviation _____	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>_____</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	_____	Composite ☐	Supplier ☐	
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_____	Composite ☐	Supplier ☐																
		MRB (QSI042) Approval																
		Disposition																
		Completed By																
		Lead hand / Supervisor Approval Verification																
		QC / QA Coordinator Approval																

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 www.dartaero.com

Date: 02/16/18

DART
 AEROSPACE
 Container No: S043502
 Part: D4634 - 143
 Job No: 167077 - K
 Serial No/Batch: S043502
 Revision: D4634
 Inspector:

Master Unit 001003
 Job No 167077 - K

Environ C Doc,	Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	Pressure/Fc Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	ULT CATEGORY <table style="width: 100%;"> <tr> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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OTHER : _____																									